

Date: Friday, 22/05/2009 4:45:52 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 48157	
Estimate Number : 12731	
P.O. Number :	Part Number : D353535 GY
This Issue : 22/05/2009 S.O. No. :	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 47524	Material :
Written By :	Due Date : 29/05/2009 Qty: 12 Um: Each
Checked & Approved By : <u>JUD 09.05.25</u>	
Comment : Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.8423 sf(s)/Unit Total: 10.1077 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: 111571 RB 9-6-1

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: B
 Prog Rev: B

RB 9-6-1

(B)

2-Deburr if necessary RB 9-6-1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECKS 08/06/02 (H3)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 1-Deburr if necessary
 2-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.
 3-Identify as D3535-35.

S 09/06/02 (B)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:45:52 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 48157

Part Number: D353535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/03 (13)

7.0

POWDER COATING

POWDER COATING



m 109091



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:05

OVEN TEMPERATURE:

320°

FINISH TIME:

8:35

FL 09/06/03

(13)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09-06-3 13

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-18

FL 09/06/03

(13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/04

Job Completion



MF 09-06-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 48157
Description: Wearshoe		Part Number: D3535-35
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	*			
1.885	+/-0.010	1.887	*			
6.00	+/-0.030	6.000	*			
6.75	+/-0.030	6.750	*			
Ø0.188	+0.005/-0.001	.192	*			
23.250	+/-0.010	23.250	*			
19.750	+/-0.010	19.750	*			
17.750	+/-0.010	17.750	*			
14.250	+/-0.010	14.250	*			
9.500	+/-0.010	9.500	*			
4.750	+/-0.010	4.750	*			
0.300	+/-0.010	.303	*			
0.300	+/-0.010	.301	*			
0.038	+/-0.010	.036	*			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-6-1	Date: 09/04/02	Date:	N/A

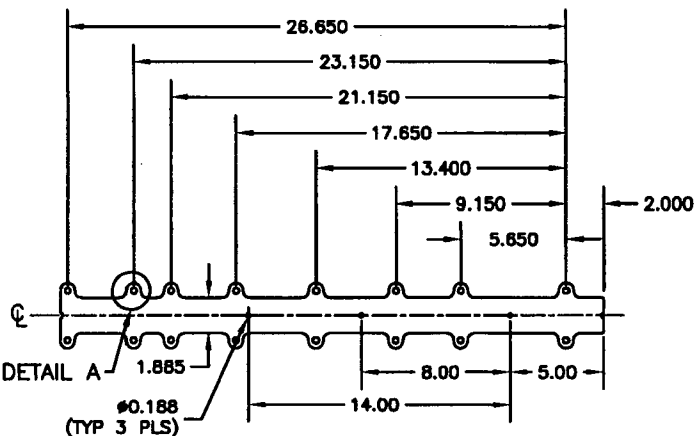
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE

DART

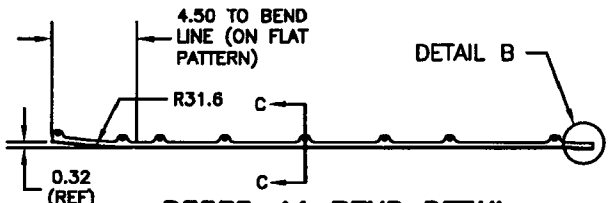
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07.04.24

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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	SCALE
B	07.04.17	1:10
MOVE TAB OUTBOARD, ADD AMS SPEC		

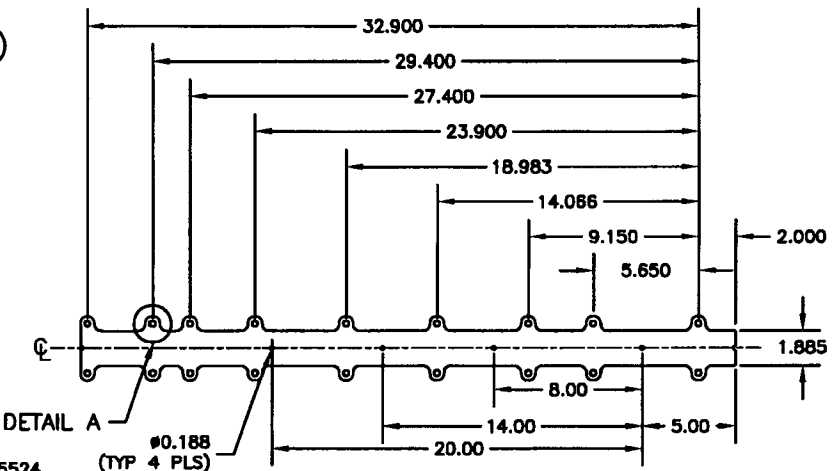


D3535-11F FLAT PATTERN

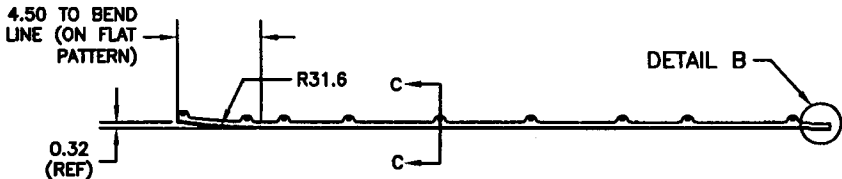


D3535-11 BEND DETAIL

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D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

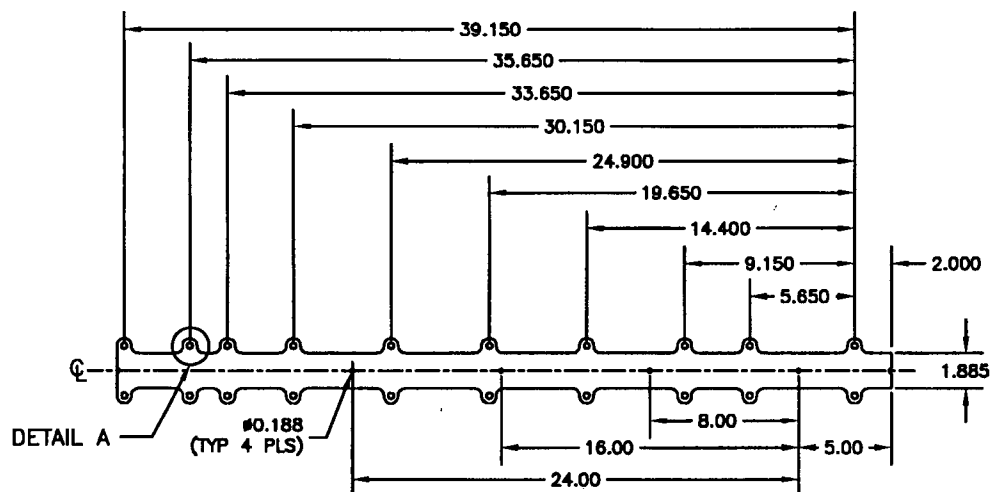
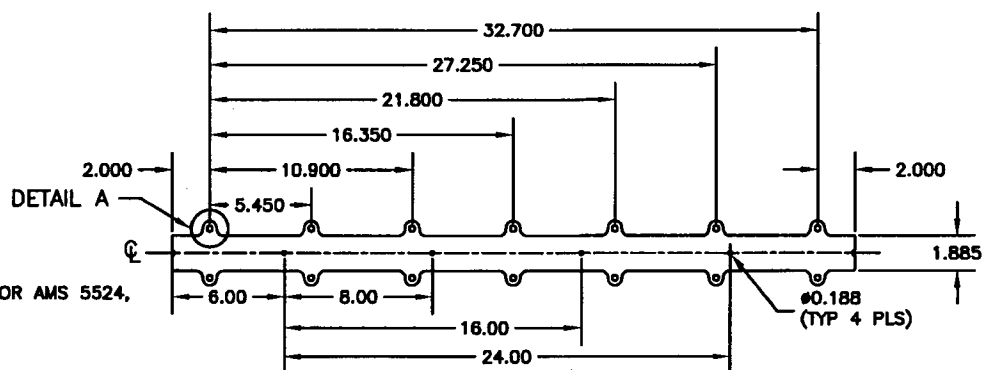
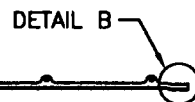
- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT C
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
 - 8) SEE PAGE 7 FOR DETAILS AND SECTION

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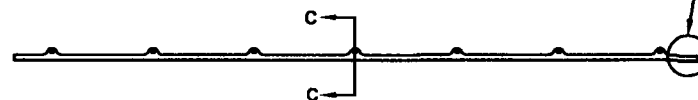
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		TITLE	WEARSHOE	SHEET 2 OF 7
				SCALE 1:10

**D3535-15F FLAT PATTERN**4.50 TO BEND
LINE (ON FLAT
PATTERN)0.32
(REF)**D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN**



DETAIL B

**D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT Q
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

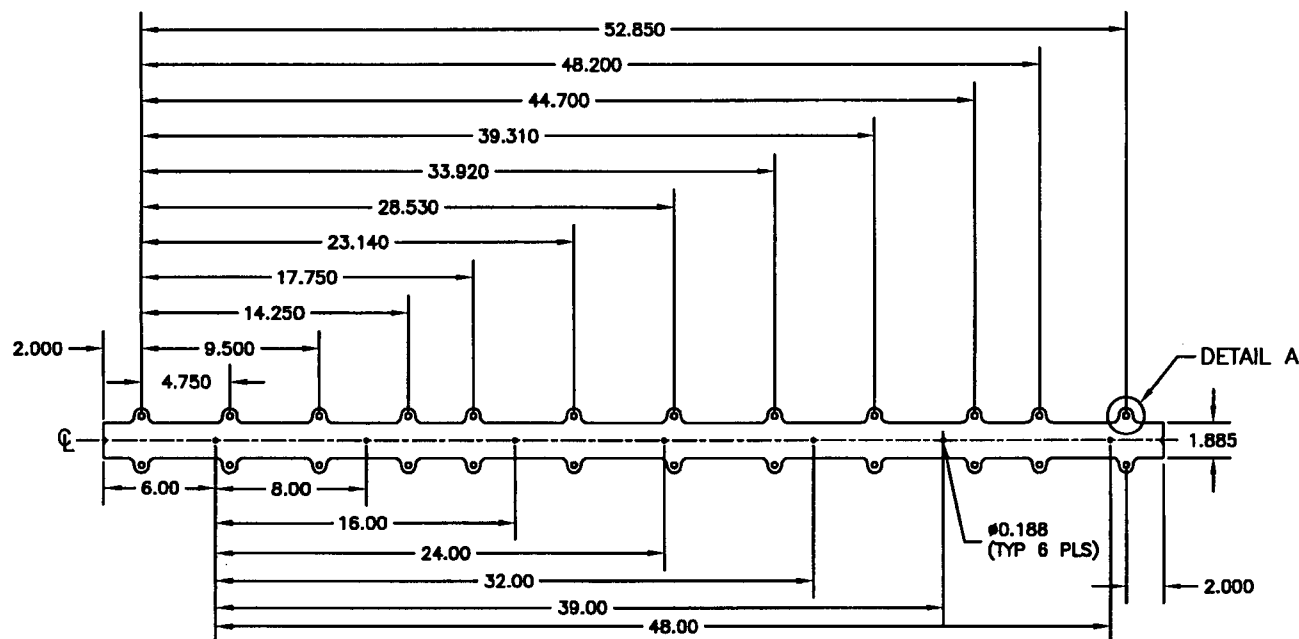
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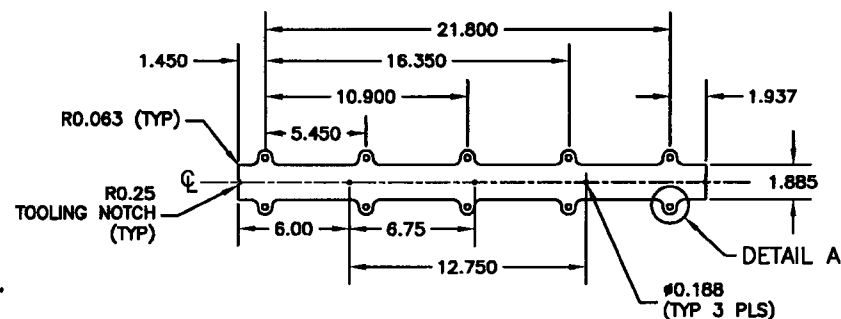
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CB	AT	PORT HADLOCK, WA		
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		D3535	SHEET 3 OF 7	
DATE		TITLE	SCALE	
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**D3535-23F FLAT PATTERN****D3535-23 BEND DETAIL**

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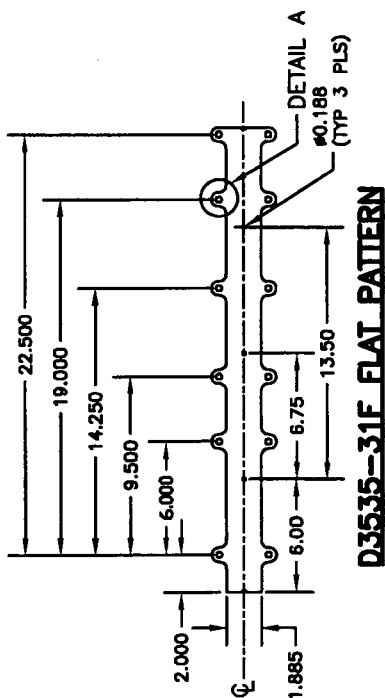
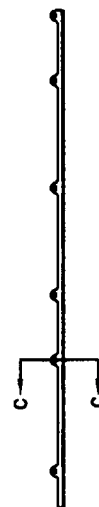
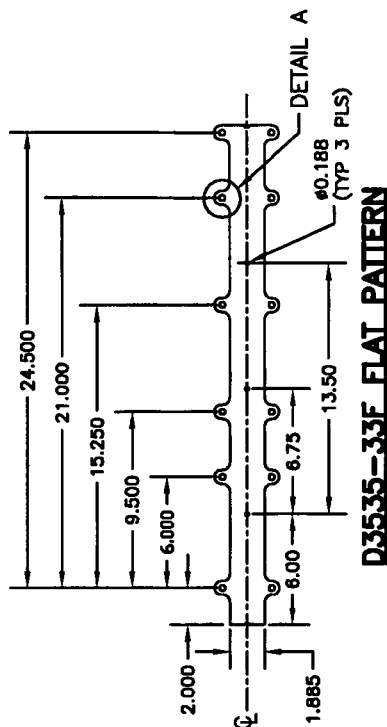
**D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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DATE 07.04.17		TITLE WEARSHOE	SCALE 1:10

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07.04.24 *[Signature]***D3535-31 BEND DETAIL****D3535-33 BEND DETAIL**

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NO. **48157**

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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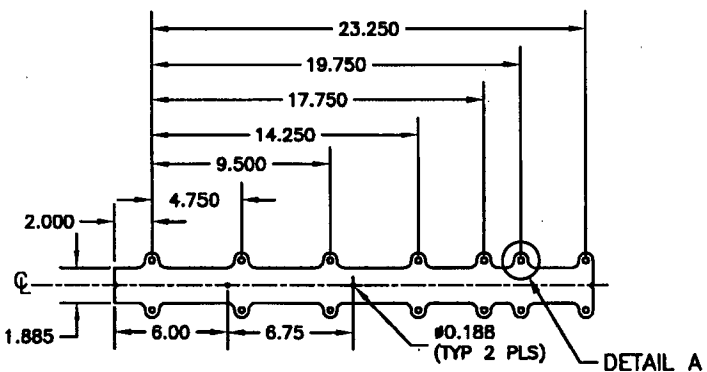
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		REV. B	SHEET 5 OF 7	SCALE
				1:10



D3535-35F FLAT PATTERN

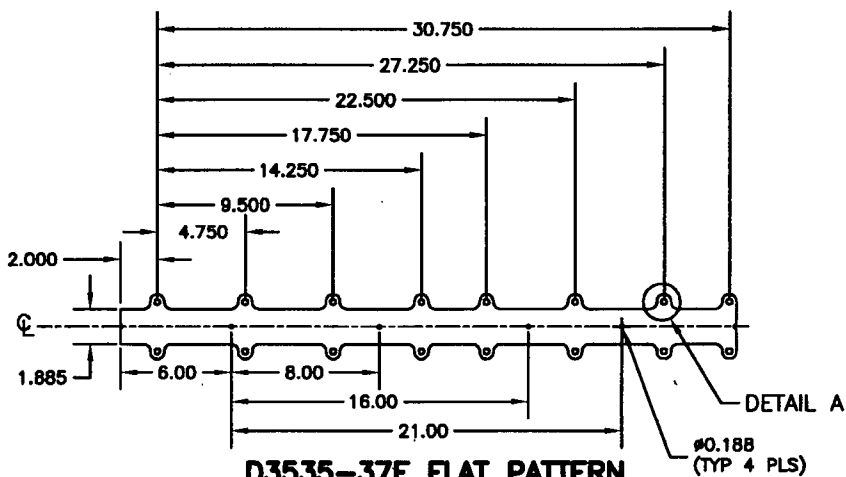


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NOTES

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D3535-37F FLAT PATTERN



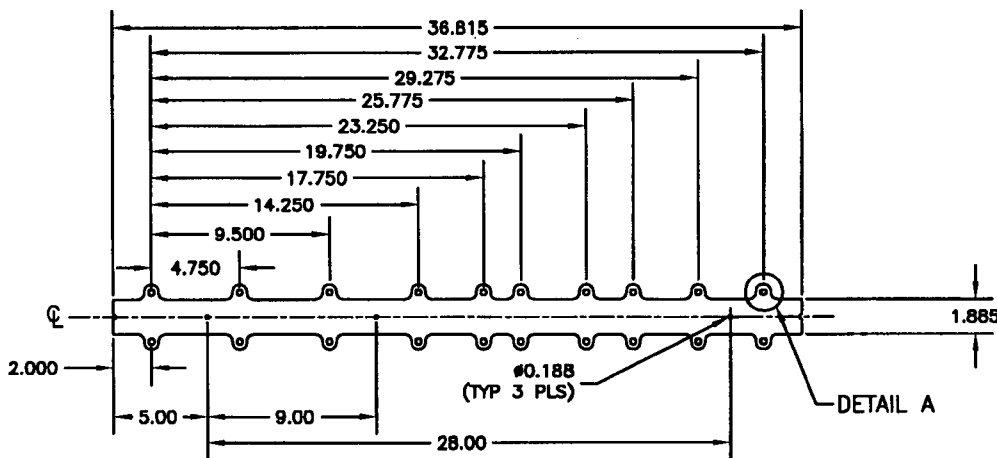
D3535-37 BEND DETAIL

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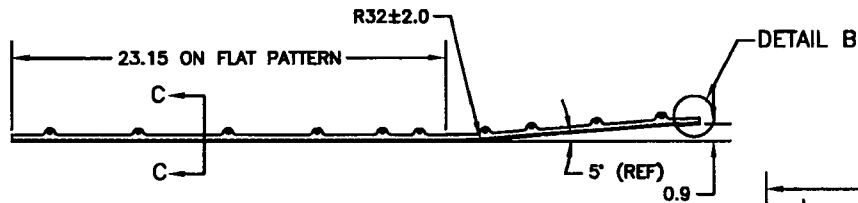
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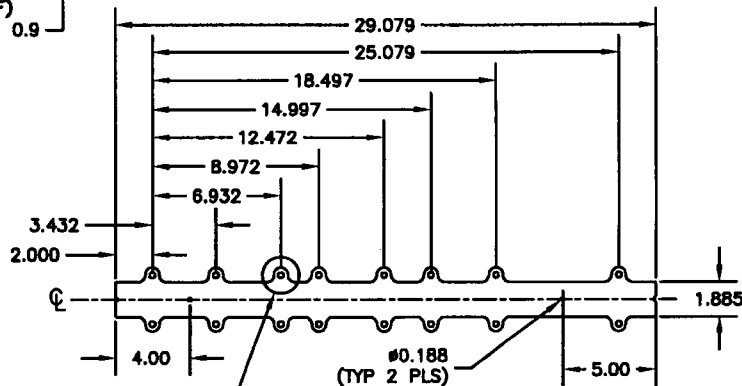
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TITLE	WEARSHOE	SHEET	6 OF 7	SCALE
				1:10



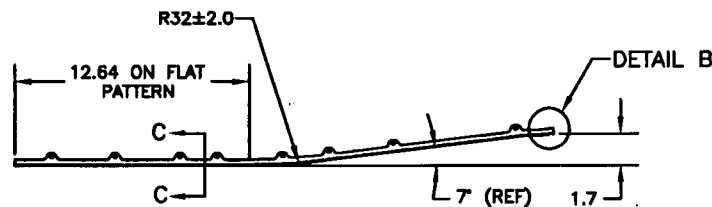
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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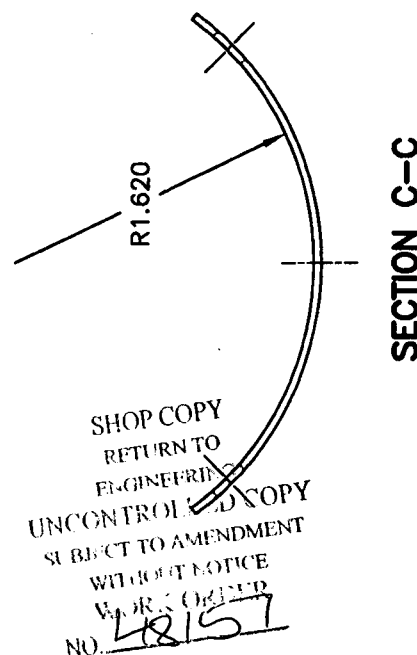
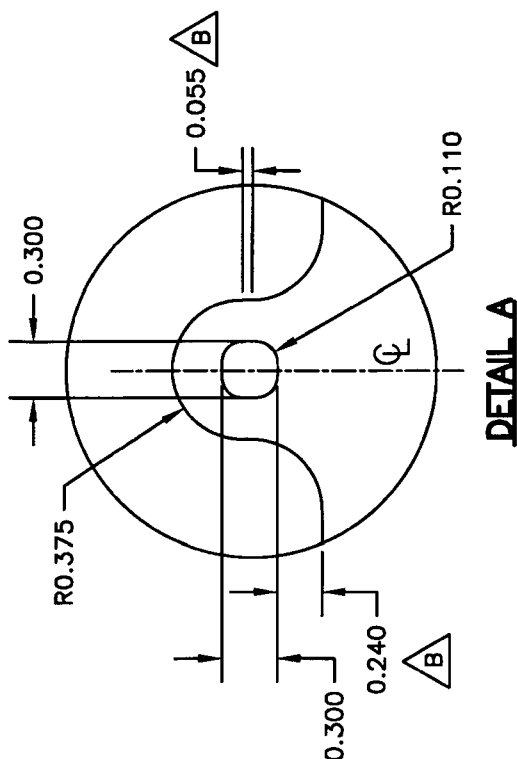
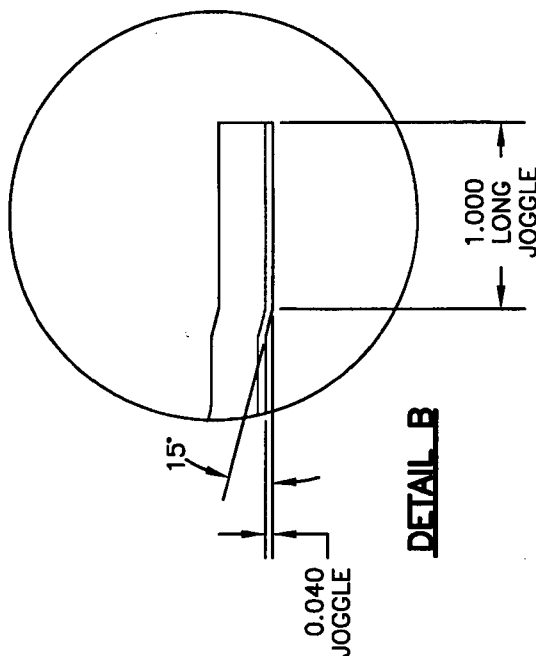
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
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DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

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07.04.24



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